

# Work Order ID 93060

November-14-12 8:28:21 AM

*Ship Nov. 20*

**\*93060\***

Page 1

Item ID: D3272-042

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Step Ass'y

Start Date: 11/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/19/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

110

0.00

**\*110\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *122358*

3-Grind End Plate flush

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*1 12-11-14*

*1 12-11-14*

**DAS 18 8-89**

# Work Order ID 93060

**\*93060\***

Page 2

November-14-12 8:28:21 AM

Item ID: D3272-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Step Ass'y  
Start Date: 11/14/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 11/19/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 15 12-11-15				1			
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1			12-11-14
150 <b>*150*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				1			DAS 23 89 12-11-15

**\*93060\***

November-14-12 8:28:21 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 11/14/12      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 11/19/12      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

OC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

\*160\*

## Large Fab

0,00

## Large Fab

## Memo

## Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSL004 & Dwg D3272  
A/RAluminum Rod 122358

### 6-Grind End Plate flush

7-Install last rivet as per Dwg.

170

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

**\*170\***

QC

## Memo

## Quality Control

0.00

1 9 14  
12.11.15

1 0 BE 12-11-5

# Work Order ID 93060

\*93060\*

Page 4

November-14-12 8:28:21 AM

Item ID: D3272-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Step Ass'y  
 Start Date: 11/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 11/19/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				1			
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				1X			12/11/15
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 8:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 8:30	0.00 0.00				1X			12/11/16

W122878

November-14-12 8:28:21 AM

**Item ID:** D3272-042

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

Stop **\*NS2\***

**Item Name:** Step Ass'y

**Start Date:** 11/14/12      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 11/19/12      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Wing Walk as per dwg QSI005 4.4 Batch 173602 0.00

\*210\*

HandFinish

## Hand Finishing

## Memo

0.00

220

### QC3- Inspect Part Finish

0.00

\*220\*

QC

## Quality Control

## Memo

0.00

230

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*230\***

### Packaging

## Packaging

## Memo

0.00

**Work Order ID 93060****\*93060\***

Page 6

November-14-12 8:28:21 AM

Item ID: D3272-042

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Ass'y

Start Date: 11/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/19/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

QC21- Final Inspection - Work Order Release

0.00

**\*240\***

QC

Memo

0.00

Quality Control

\_\_\_\_\_  
MLJ 12-11-19ME  
12-11-19

# Picklist Print

November-14-12 8:28:20 AM

Page 1

Work Order ID: 93060

Parent Item: D3272-042

Parent Item Name: Step Ass'y

Start Date: 11/14/12

Required Date: 11/19/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.14 as per dwg revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120 Step Extrusion		Manufactured	No	B 89750		110	Each	0.0000	1	1		12.11.14	
D3065-041 Step Leg Assembly Hi		Manufactured	No			160	Each	33.0000	1	1		12.11.15	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		33							
				66149		0							
				79336		1							
				90012		32			1				
D3066-1 Spacer		Manufactured	No			110	Each	183.0000	2	2		12.11.15	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		183							
				90212		34							
				90346		29			2				
				90347		60							
				92567		60							
D3067-1 End Plate		Manufactured	No			110	Each	165.0000	1	1		12.11.14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		161							
				78608		4							
				83855		1							
				90178		1							
				90335		35			1				
				90336		60							
				90486		60							
				WA016		4							
				67582		2							
				68214		1							
				79607		1							

D3272-1

B#93088

1

12.11.14

# Picklist Print

November-14-12 8:28:20 AM

Page 2

Work Order ID: 93060  
Parent Item: D3272-042  
Parent Item Name: Step Ass'y

Start Date: 11/14/12

Required Date: 11/19/12

Start Qty: 1.00

Required Qty: 1.00

D3067-1  
End Plate

Manufactured No

160

Each

165.0000

1

1

12.11.15

Location	Loc Qty	Loc Code
WA	161	
78608	4	
83855	1	
90178	1	
90335	35	
90336	60	
90486	60	
WA016	4	
67582	2	
68214	1	
79607	1	

MS20600-AD4W4  
Rivets

Purchased No

160

Each

2,130.0000

16

16

12.11.15

Location	Loc Qty	Loc Code
321	18	
121652	18	
ST311	1844	
123021	844	
123525	1000	
ST321	268	
121011	9	
121340	39	
121444	220	

\* B 3219-1

B 89967

2

12.11.14



**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED***07 06 04 -ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

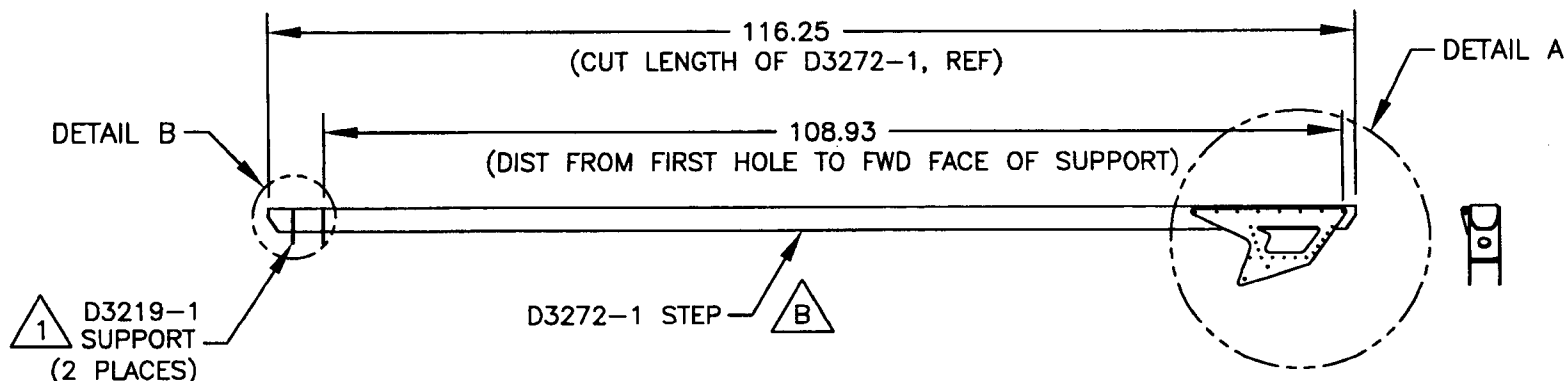
**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

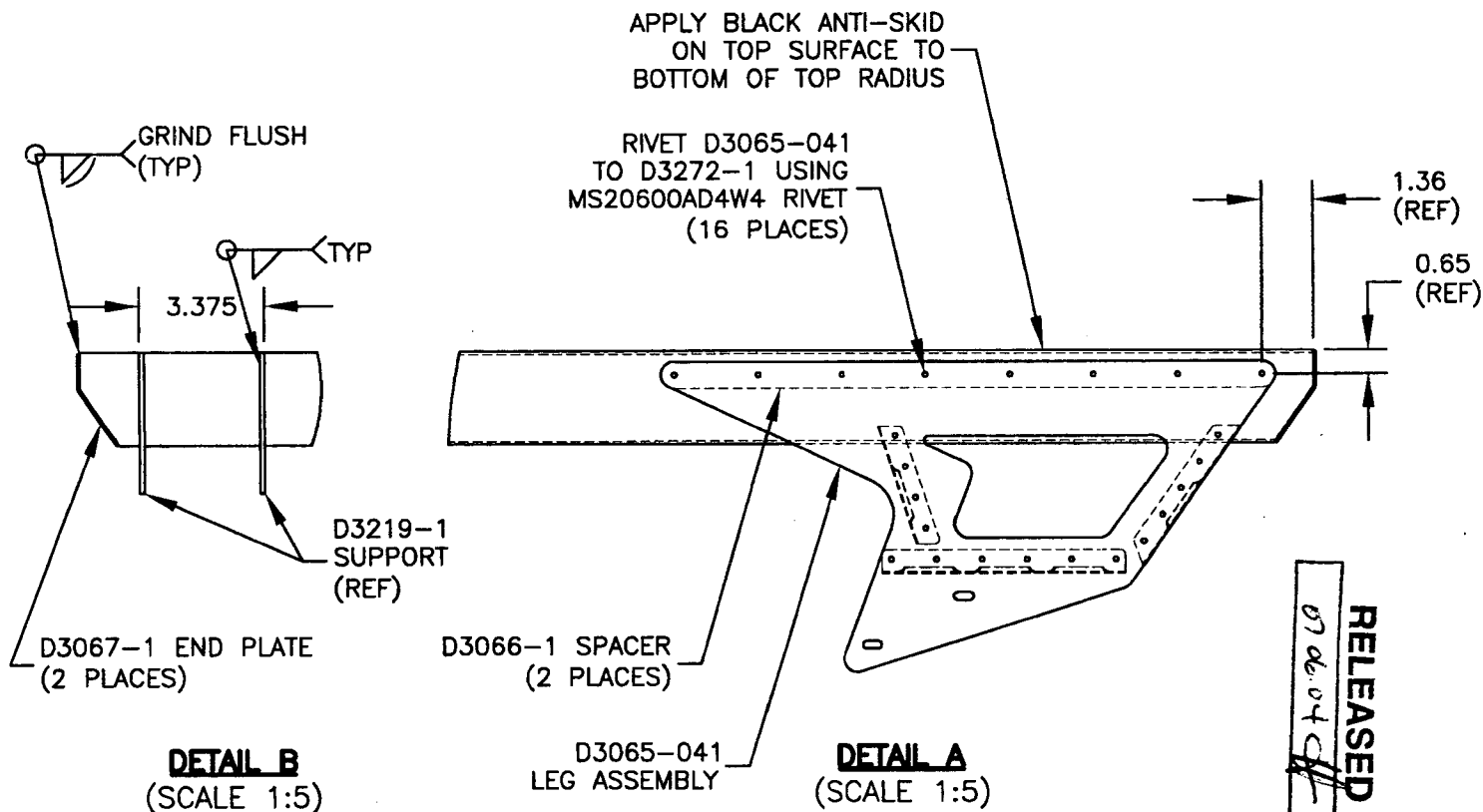
**Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



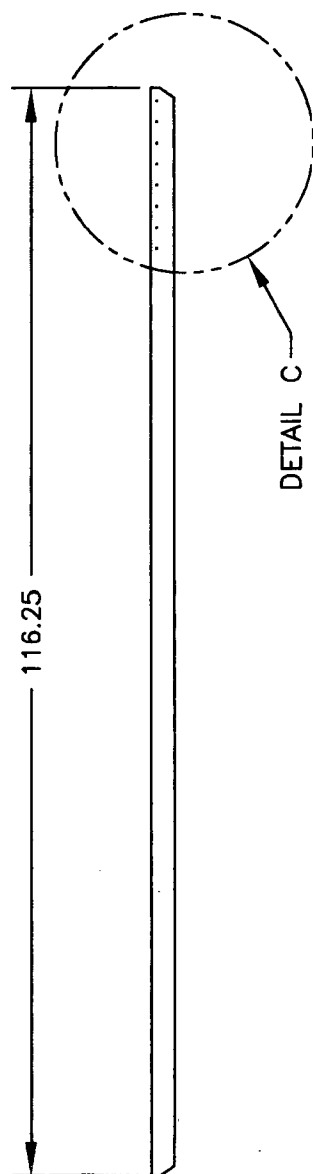
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
07.05.18	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE
		1:20



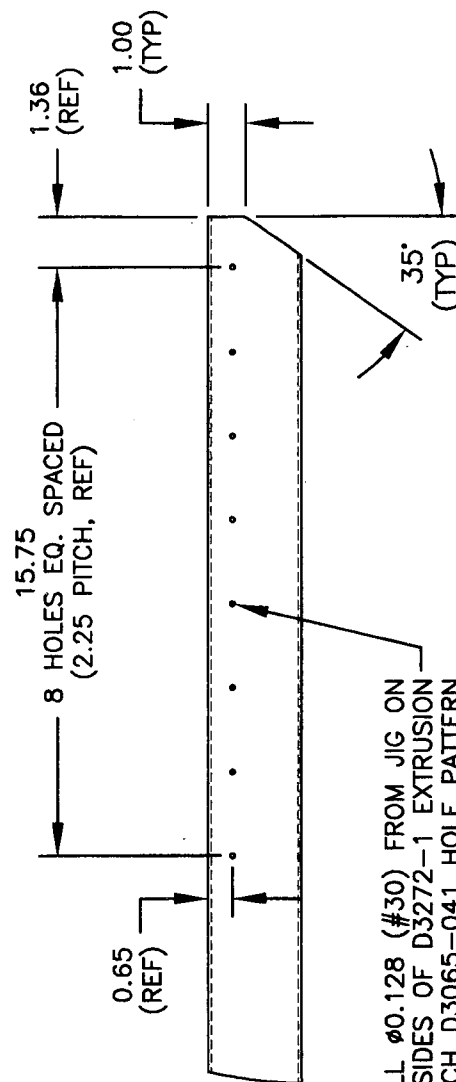
DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*



**DETAIL C**  
**△ D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

DRILL 0.128 (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.